

der ID 84151

8:51:21 AM

D3870-3

Revision ID:

Item Name: Rib

Start Date: 5/04/12

Start Qty: 2.00

Required Date: 5/07/12

Req'd Qty: 2.00

Reference:

Approvals:

Process Plan:

Date:

QC:

Date:

Tooling:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

100

100

Waterjet

FLOW CNC Waterjet

6061 .250 x 6.00

FLOW WATER JET

Memo

1-Cut as per Dwg D3870

Dwg Rev: A

Prog Rev: A

2-Deburr edges and holes if necessary

0.00

0.00

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

120

120

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Work Order ID 84151

May-04-12 8:51:21 AM

84151

Page 2

Item ID: D3870-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Rib

Start Date: 5/04/12 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 5/07/12 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

130

Identify as per dwg & Stock Location: *Wic*

0.00

130

Packaging

Memo

0.00

Packaging

2x *SP*
12-05-7

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

12/5/8

12-05-7

Picklist Print

May-04-12 8:51:20 AM

Page 1

Work Order ID: 84151

Parent Item: D3870-3

Parent Item Name: Rib

Start Date: 5/04/12

Required Date: 5/07/12

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 09-01-20 as per prelim issue DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.250X06.000		Purchased	No			100	f	15.2000	0.17	0.34			
6061-T6 Bar .250 x 6.00													

Location

Loc Qty

Loc Code

MAT001

15.2

117379

3.2

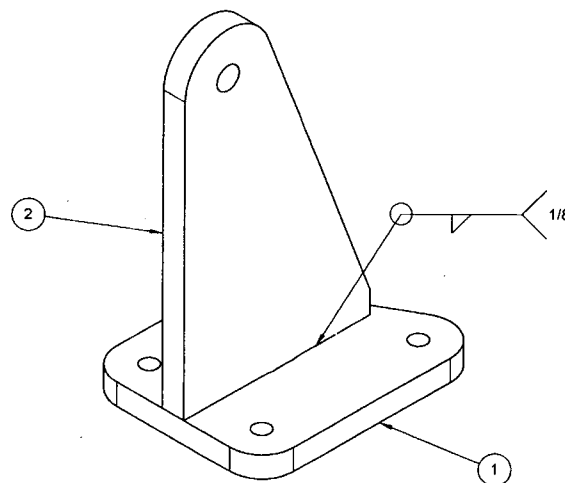
121040

12

117379

Jm/Wj
12-5-4

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. -041
1	D3870-1	BASE	1
2	D3870-3	RIB	1



D3870-041 FWD LH HARDPOINT

W/O 841081

RELEASED
09/01/11

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3870-041" & B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.09 lbs
- 8) WELD PER DART QSI 004

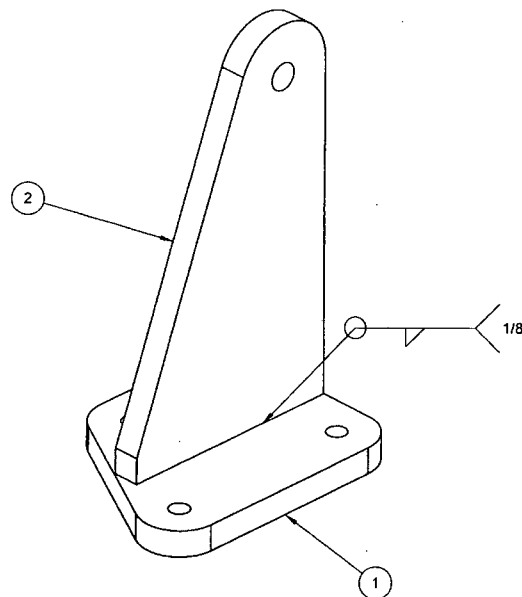
A	NEW ISSUE		08.12.11
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.12.11		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3870** REV. A
SHEET 1 OF 5
TITLE **MOUNT** SCALE NTS

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ITEM NO.	PART NUMBER	DESCRIPTION	QTY. -042
1	D3870-1	BASE	1
2	D3870-3	RIB	1



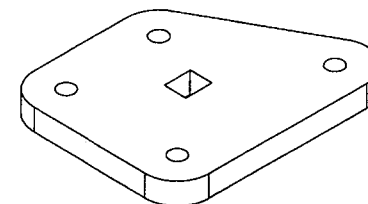
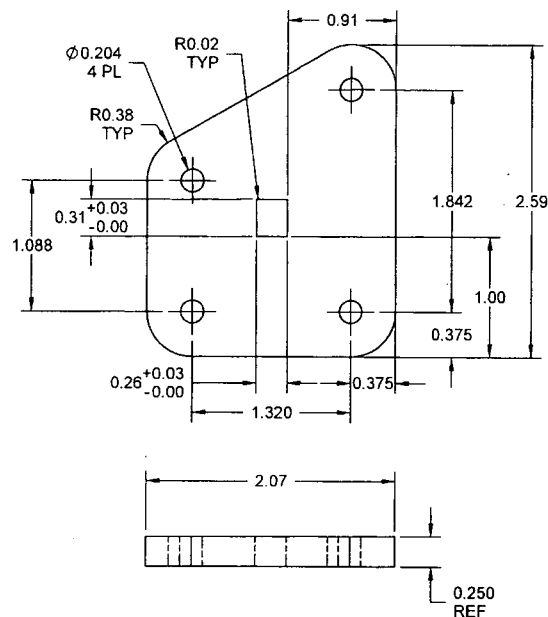
D3870-042 FWD RH HARDPOINT

RELEASED
07/01/12 MHT

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3870-042" & B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.09 lbs
- 8) WELD PER DART QSI 004

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DRAWN	SEI	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SEI	DRAWING NO.	REV. A
MFG. APPR.	SEI	D3870	SHEET 2 OF 5
APPROVED	SEI	TITLE	SCALE
DE APPR.	SEI	MOUNT	NTS
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D3870-1 BASE

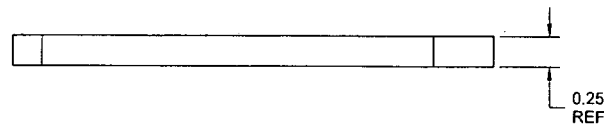
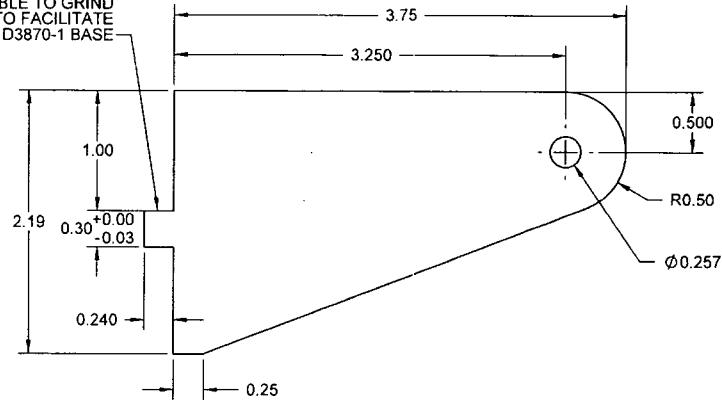
RELEASED
9/6/21 MW

NOTES:

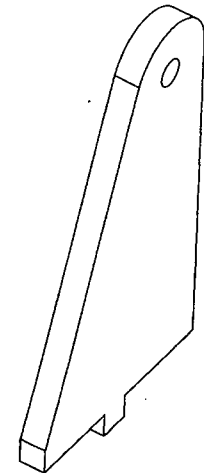
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.25 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.250)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3870	SHEET 3 OF 5
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IT IS ACCEPTABLE TO GRIND
CORNERS TO FACILITATE
FITTING TO THE D3870-1 BASE



D3870-3 RIB

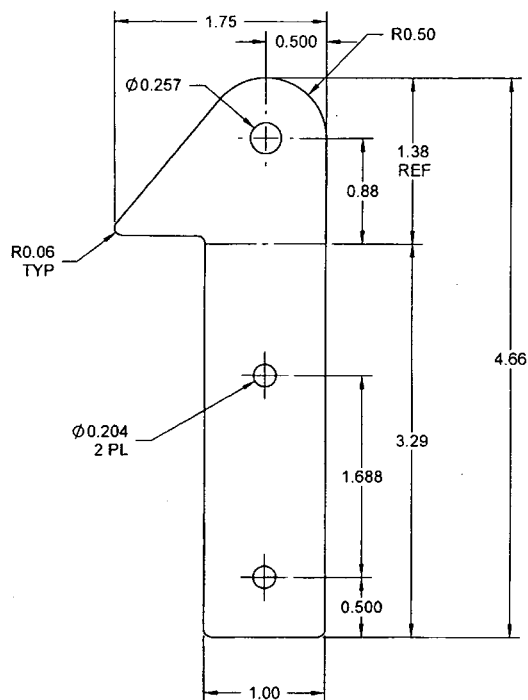


RELEASED
07/14/11

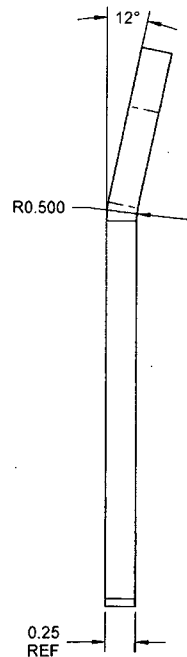
NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.25 THICK PER AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.250)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.05 lbs

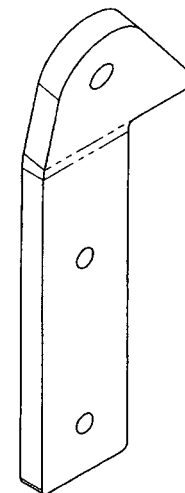
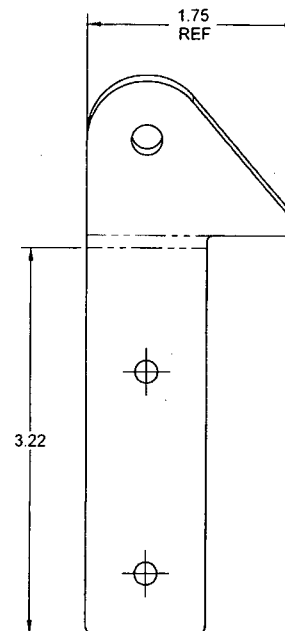
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MFG. APPR.		D3870	SHEET 4 OF 5
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D3870-5F FORWARD UPPER MOUNT FLAT PATTERN



D3870-5 FORWARD UPPER MOUNT
MADE FROM D3870-5F



RELEASED
07/11/11

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.25 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.250)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs

DESIGN		DART AEROSPACE LTD	
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CHECKED		DRAWING NO. D3870	REV. A
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DE APPR.			NTS
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